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647.4312
Job Sheet 211915



Part No: 647.4312

Job Qty: 6 pcs

Part Name: LH Upper Strut



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/31/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/18/20

Type: SOLD

Description:

Note: DWG REV A SHEET 2 IPP REV:A 12.10.26 NEW ISSUE DD VERF:JLM IPP REV:B 14.11.06 CHG MATERIAL TO S.S. DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Waterjet - Flow - 1	6 pcs		8/17/20	0.17	0.60	Waterjet - Flow		20/08/10
120	QC 2	6 pcs		8/17/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		20/08/10
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
130	QC 8	6 pcs	8/17/20	0.00 0.00	QC 8 - 12
					QC 8 - 14
					QC 8 - 17
					QC 8 - 20
					QC 8 - 25
					QC 8 - 3
					QC 8 - 32
					QC 8 - 33
					QC 8 - 35
					QC 8 - 39
					QC 8 - 4
					QC 8 - 44
					QC 8 - 45
					QC 8 - 49
					QC 8 - 58
					QC 8 - 8
					QC 8 - 9
					QC 8 - 68
					QC 8 - 67
					QC 8 - 1 (A)
					QC 8 - 47
					QC 8 - 40
					QC 8 - 52
					QC 8 - 23
					QC 8 - 57
					QC 8 - 76
					QC 8 - 61
					QC 8 - 66
					QC 8 - 73
					QC 8 - 82
140	Large Fab - Welded Assy-2-B4B	6 pcs	8/17/20	0.00 3.30	Large Fab - 1 - B4B
					Large Fab - 10 - B4B
					Large Fab - 2 - B4B
					Large Fab - 3 - B4B
					Large Fab - 4 - B4B
					Large Fab - 5 - B4B
					Large Fab - 6 - B4B
					Large Fab - 7 - B4B
					Large Fab - 8 - B4B
					Large Fab - 9 - B4B
					Large Fab - 11 - B4B (Various)
					Large Fab - 12 - B4B
150	QC 5	6 pcs	8/17/20	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3

AUG 10 2020

DAS
40
89

MV Sept 3/20

					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	DAS
					QC 5 - 50	50 7-2-20
					QC 5 - 30	9-89
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
160	Large Fab - Basket - 2 - B4B	6 pcs	8/17/20	0.00 3.87	Large Fab - 1 - B4B	
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	MV Sep 3/20
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
					Large Fab - 12 - B4B	
170	QC 9	6 pcs	8/17/20	0.00 0.00	QC 9 - 10	
					QC 9 - 18	
					QC 9 - 24	
					QC 9 - 43	DAS
					QC 9 - 50	50 9-10-20
					QC 9 - 9	9-89
180	QC 5	6 pcs	8/17/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	DAS
					QC 5 - 50	50 9-10-20
					QC 5 - 30	9-89
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					QC 5 - 82	
190	Spray Paint - 2 - B4B	6 pcs	8/18/20	0.00 0.41	Spray Paint - 1 - B4B	
					Spray Paint - 2 - B4B	
					Spray Paint - 3 - B4B	DAS
					Spray Paint - 4 - B4B	87 SEP 10 2020
200	QC 14	6 pcs	8/18/20	0.00 0.00	QC 14 - 15	9-89
					QC 14 - 2	
					QC 14 - 34	
					QC 14 - 41	

				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	DAS
				QC 14 - 81	87
				QC 14 - 82	9-89
				QC 14 - 87	
				QC 14 - 47	
210	Packaging 3-1 - Stock - B4B	6 pcs	8/18/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B ✓
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
220	QC 21 - SA	6 pcs	8/18/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 9
					QC 21 - SA - 77

SEP 11 2020

SEP 11 2020

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DAS

SEP 14 2020

Part Op 110 - 1-Cut 6474300 plate 3.928X1.985 as per Dwg
 Descriptions: 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - 1- Fabricate tube as per dwg by cutting (22.00") one end 27.7 degree and other end punch, bend and drill hole as per dwg

- 150 - (QC5- Inspect part completeness to step on W/O)
 160 - Weld per dwg A/R S.S. rod Batch: N139023 Weld tube to plate as per dwg.
 170 - (QC9- Inspect visual per QSI004- Fusion Welds)
 180 - (QC5- Inspect part completeness to step on W/O)
 190 - (Spray Paint / NDT Room) Prime as per dwg (see note 4) 5265778
 200 - (QC14- Inspect Spray Paint)
 210 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***
 220 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	.3240 sf (.054 ea)	110-Waterjet - Flow - 1	<u>S247303/S288303</u>
M304TR0.500W.049	304 Round Tube .500 X .049W	10.9800 ft (1.83 ea)	140-Large Fab - Welded Assy-2- B4B	<u>232352 x5</u> <u>244043 x1</u> <u>S292091</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Waterjet - Flow - 1	M304S16GA	0	1	0
140-Large Fab - Welded Assy-2- B4B	M304TR0.500W.049	11	97	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	LH Upper Strut	1.985inches ± 0.005	1.990 1.980	<u>1.990</u>	
2	LH Upper Strut	3.928inches ± 0.005	3.933 3.923	<u>3.927</u>	
3	LH Upper Strut	0.063inches ± 0.005	0.068 0.058	<u>.058</u>	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S293005



Part: 647.4312

Job No: 211915

Serial No/Batch: S293005

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

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